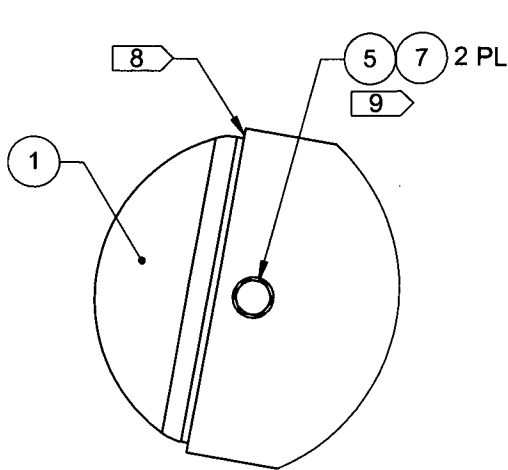
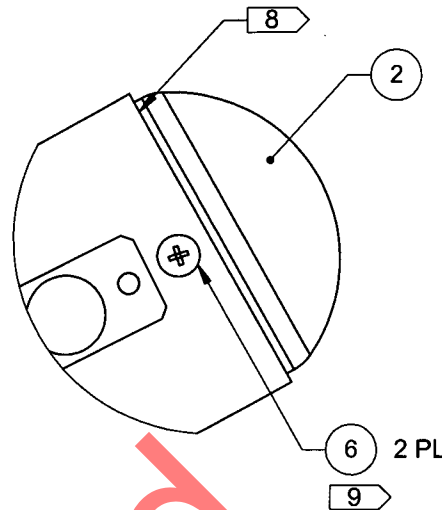


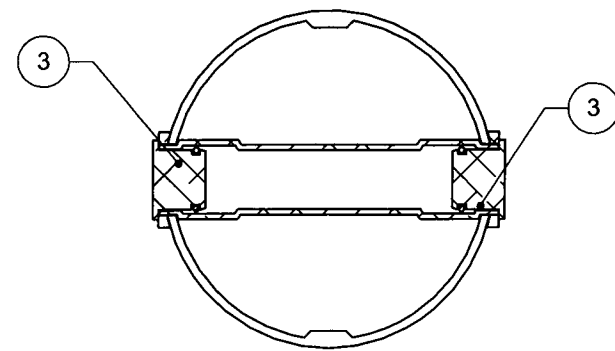
| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|-------------------|
| | X | D4766-041 | SKIDTUBE |
| 1 | 1 | D2965 | CAP |
| 2 | 1 | D2965-3 | CAP |
| 3 | 4 | D3492-055 | PLUG ASSY |
| 4 | 1 | D4766-043 | SKIDTUBE SUB ASSY |
| 5 | 2 | AN3C5A | BOLT |
| 6 | 2 | AN526C1032R10 | SCREW |
| 7 | 2 | NAS1149C0332R | WASHER |



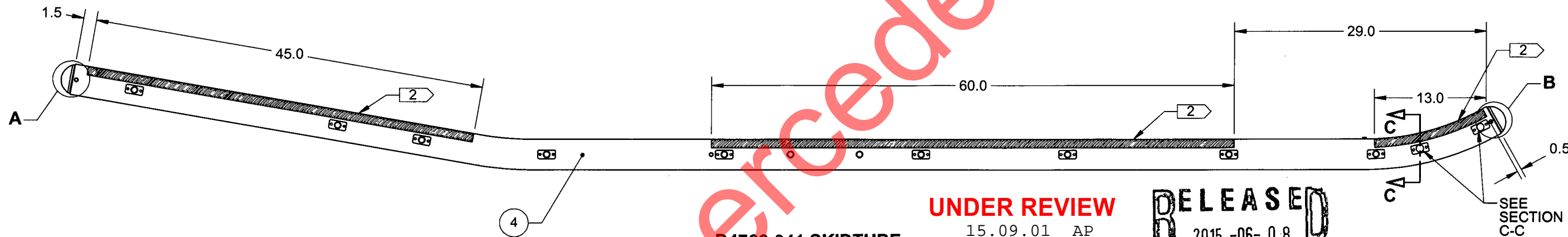
DETAIL A
SCALE 6X



DETAIL B
SCALE 6X



SECTION C-C
SCALE 6X
2 PL



D4766-041 SKIDTUBE

UNDER REVIEW
15.09.01 AP
URF15-615

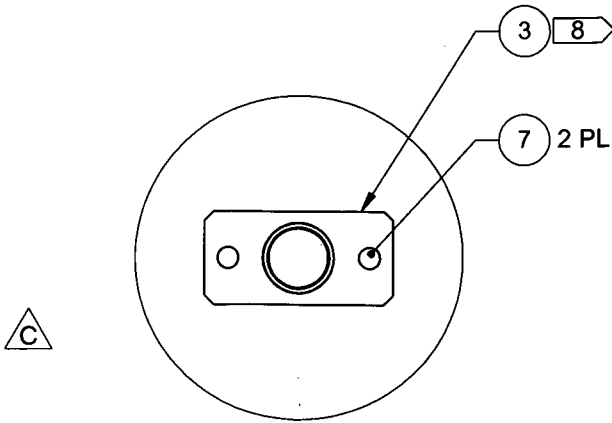
RELEASED
R 2015-06-08
ELN 15-551

| C | RE-ORGANIZED SECTIONAL/DETAIL VIEWS ALL SHTS; IDENTIFICATION MOVED FROM SHT 1 TO SHT 5; SECTION D-D AND DETAIL K 11PL WAS 12PL; MODIFIED D4766-043 FINISH; Ø0.750 WAS Ø0.758 (B4-3); D5085-1 WEB WAS D4768-1; VARIOUS MINOR DIM CHANGES TO D4766-1/-045 TO MATCH STD SKIDTUBE PROFILE; 35.9 WAS 29.1 (B7-4); GROUNDING FASTENER MOVED AFT 0.25 (D5-5); D2965 HARDWARE AND GROUNDING HARDWARE CHANGED TO STAINLESS; ADD NOTE 9 (SHT 1) AFT FLOAT HOLES NOW DIMENSIONED AFTER AFT BEND | AP | 15.02.25 |
|------------|--|---|----------|
| B | FWD CAP WAS D2965 NOW D2965-3. D3492-055 WAS D3492-051. SWAGING NOW 0.650 WAS 0.661 (C7-2). ADDED BENDING DETAIL TO SHEET 4. MATERIAL D2962-190 WAS D2962-185 (A7-5). ADDED DETAIL L ON SHT 3. ADDED TOP VIEW ON SHT 5. REPLACED D4768-1 WITH D4927-041 ON SHT 3. GROUND HANDLING THRU HOLES SPACERS NOW WELDED. SEE SECTION H-H (B4-2). RE-ORDERED SECTIONS AND DETAILS. | AP | 13.08.08 |
| A | NEW ISSUE | AP | 13.02.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AP | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | AP | | |
| CHECKED | AJS | DRAWING NO. REV. C | |
| MFG. APPR. | DD | D4766 SHEET 1 OF 5 | |
| APPROVED | HS | TITLE SCALE | |
| DE APPR. | DS | SKIDTUBE NTS | |
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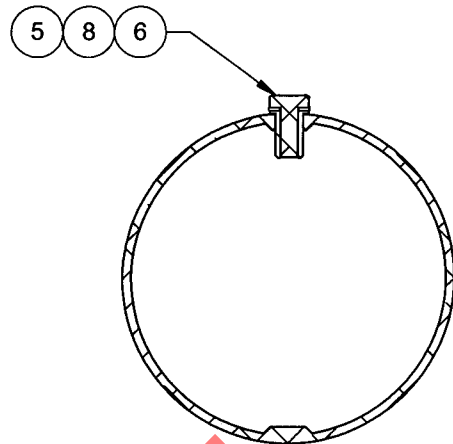
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 32.87 lbs
- 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890 OR MIL-S-8802 CLASS B2 SEALANT

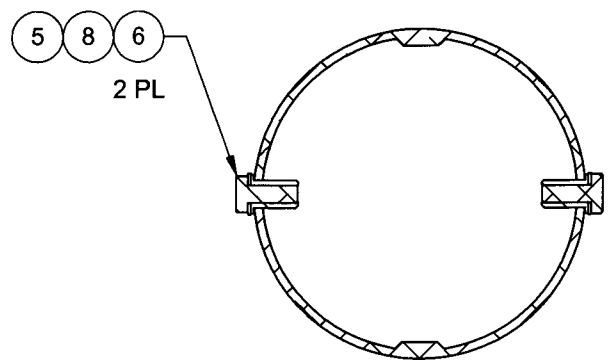
| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|---------------|-------------------|
| | X | D4766-043 | SKIDTUBE SUB ASSY |
| 1 | 2 | D2973 | SPACER |
| 2 | 11 | D4686-1 | SPACER |
| 3 | 22 | D4753-1 | DOUBLER |
| 4 | 1 | D4766-045 | SKIDTUBE SUB ASSY |
| 5 | 3 | AELS-1032-130 | INSERT |
| 6 | 3 | AN3C4A | BOLT |
| 7 | 44 | MS20601AD4W3 | RIVET, BLIND, CSK |
| 8 | 3 | NAS1149C0332R | WASHER |



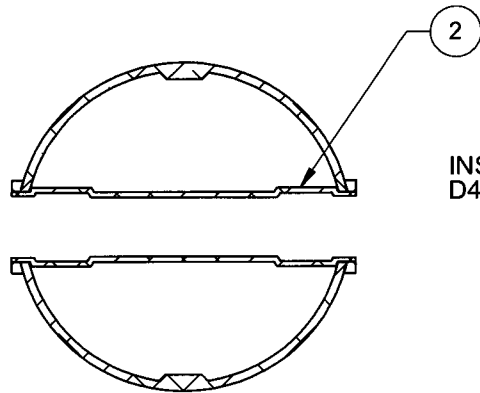
DETAIL F
SCALE 6X
22 PL



SECTION E-E
SCALE 6X



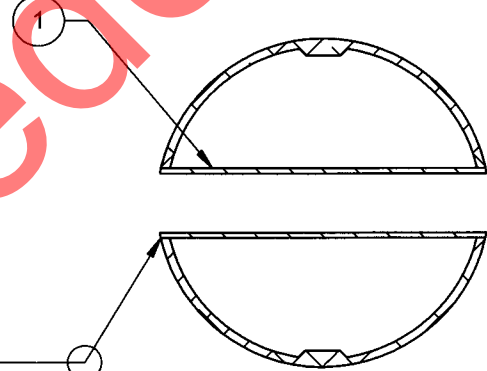
SECTION G-G
SCALE 6X



SECTION D-D
SCALE 6X
11 PL

INSTALL D4686-1 SPACER AFTER INSTALLING
D4753-1 DOUBLERS AS FOLLOWS (11 PL)

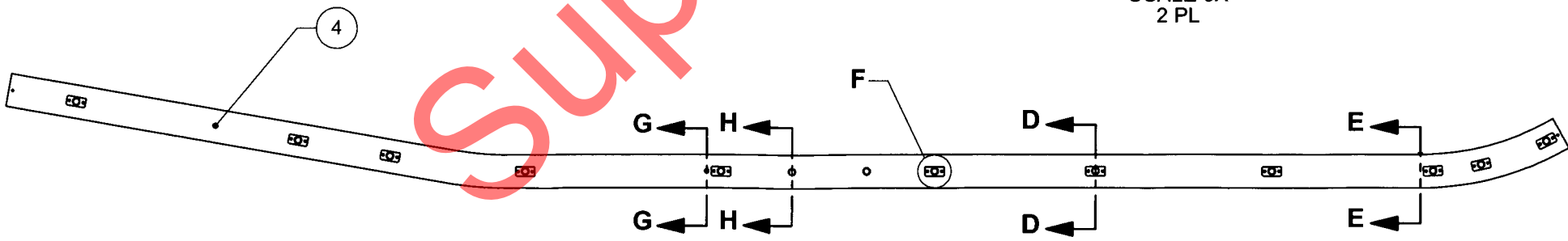
1. INSERT D4686-1 SPACER
2. SWAGE TO $\varnothing 0.650 +0.010/-0.000$ X 1.0 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



SECTION H-H
SCALE 6X
2 PL

INSTALL D2973 SPACER AS FOLLOWS (2 PL)

1. CHAMFER HOLE 0.030X45 DEG
2. INSERT D2973 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS $\varnothing 0.625$ DRILL TO REMOVE SPILL OVER



D4766-043 SKIDTUBE SUB ASSY

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2015-06-08

NOTES:

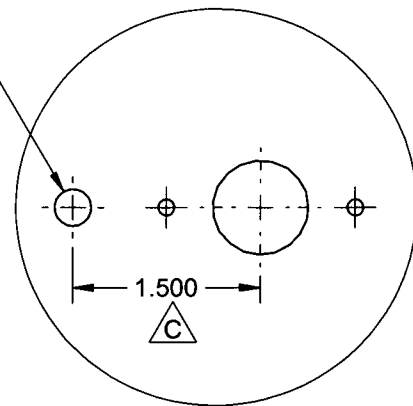
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 31.69 lbs
- 8) SEAL FAYING SURFACES USING PROSEAL P/S 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) WELDING: PER QSI 004

APPROVED

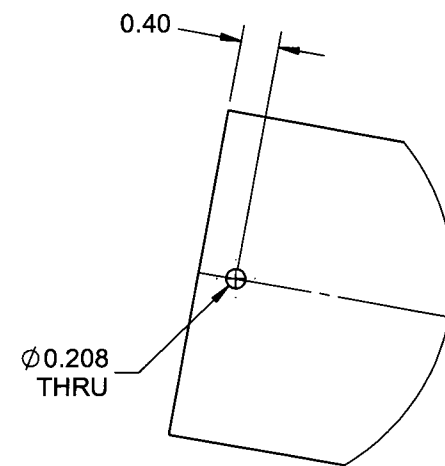
| | |
|------------|----------|
| DESIGN | AP |
| DRAWN | AP |
| CHECKED | AJS |
| MFG. APPR. | DD |
| APPROVED | HS |
| DE APPR. | DS |
| DATE | 15.02.25 |

| | |
|---|------------------------|
| DART AEROSPACE USA, INC. KENT, WA | |
| DRAWING NO. D4766 | REV. C SHEET 2 OF 5 |
| TITLE SKIDTUBE | SCALE NTS |
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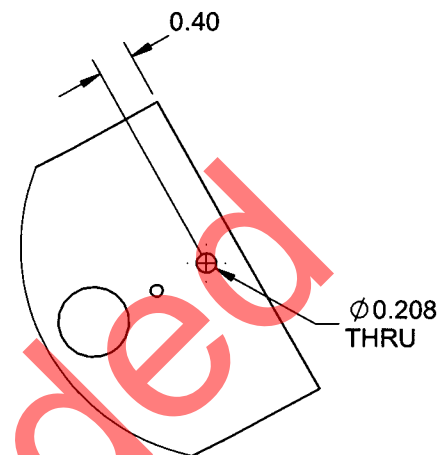
| ITEM | QTY -045 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------------|
| | X | D4766-045 | SKIDTUBE SUB ASSY |
| 1 | 1 | D4766-1 | SKIDTUBE |
| 2 | 1 | D5085-1 | WEB |



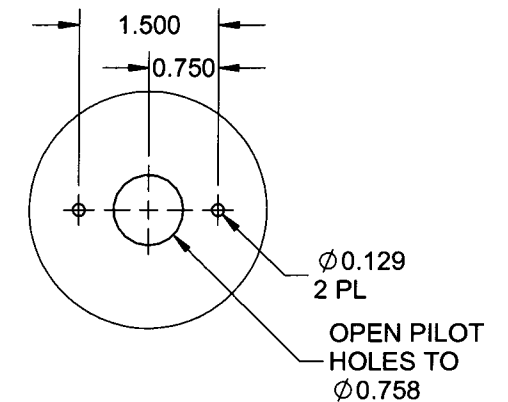
DETAIL L
SCALE 4X



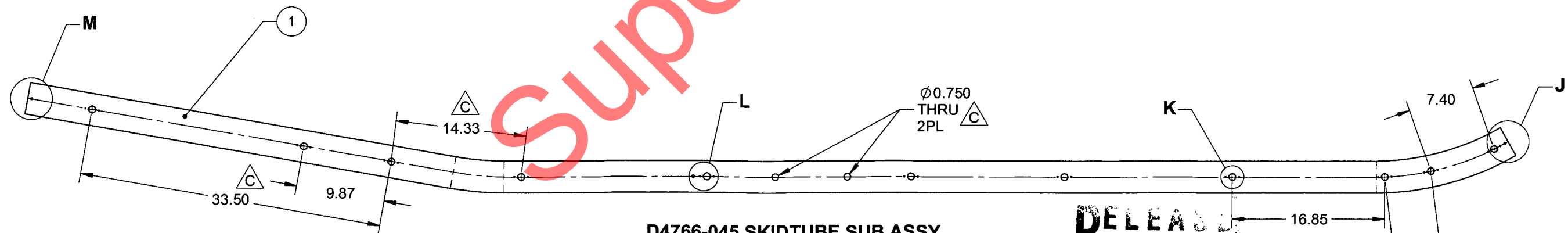
DETAIL M
SCALE 6X



DETAIL J
SCALE 6X



DETAIL K
11 PL (BOTH SIDES)
SCALE 6X



D4766-045 SKIDTUBE SUB ASSY

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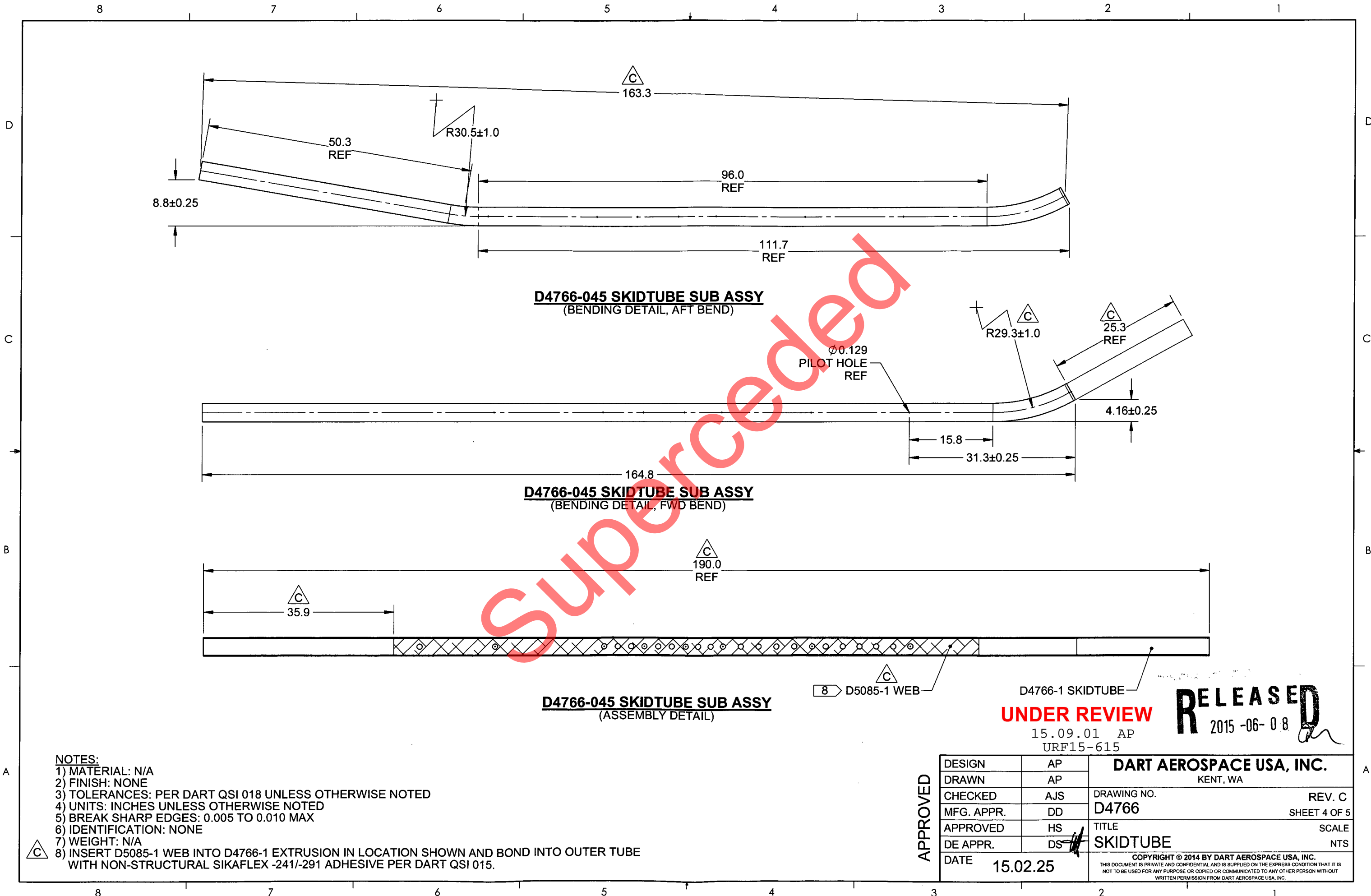
NOTES:

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 31.69 lbs

RELEASE
2015-06-08

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| | | | |
|---------------|-----|---|--------------|
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| CHECKED | AJS | DRAWING NO. | REV. C |
| MFG. APPR. | DD | D4766 | SHEET 3 OF 5 |
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| DE APPR. | DS | SKIDTUBE | NTS |
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D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, AFT BEND)

D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, FWD BEND)

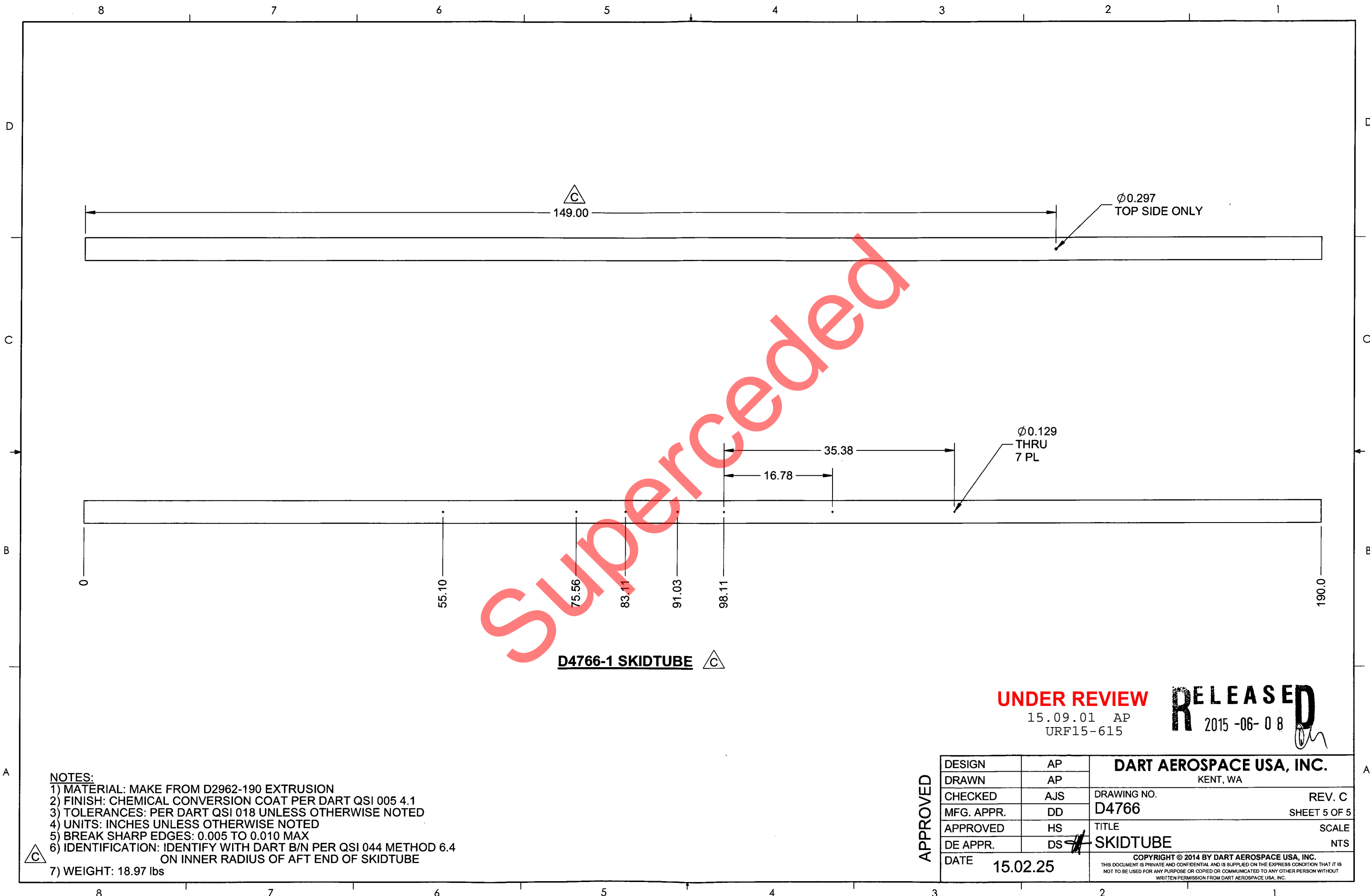
D4766-045 SKIDTUBE SUB ASSY
(ASSEMBLY DETAIL)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) INSERT D5085-1 WEB INTO D4766-1 EXTRUSION IN LOCATION SHOWN AND BOND INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.

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| | | | |
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| MFG. APPR. | DD | D4766 | SHEET 4 OF 5 |
| APPROVED | HS | TITLE | SCALE |
| DE APPR. | DS | SKIDTUBE | NTS |
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D4766-1 SKIDTUBE

- NOTES:**
- 1) MATERIAL: MAKE FROM D2962-190 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF AFT END OF SKIDTUBE
 - 7) WEIGHT: 18.97 lbs

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| | | | |
|------------|----------|--|--------------|
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| DRAWN | AP | | |
| CHECKED | AJS | DRAWING NO. | REV. C |
| MFG. APPR. | DD | D4766 | SHEET 5 OF 5 |
| APPROVED | HS | TITLE | SCALE |
| DE APPR. | DS | SKIDTUBE | NTS |
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